

**Work Order ID 71795**

Tuesday, July 12, 2011 9:51:51 AM



Page 1

Item ID: D3512-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 7/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/18/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11-08-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3512	Rev C

100



FLOW WATER JET

Waterjet

Memo

0.00

MAT NOT PULLED

B11-7-12

FLOW CNC Waterjet

304.063

I-Cut as per Dwg D3512  Dwg Rev: C  Prog Rev: C  2-  
Deburr if necessary

(12)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

B11-7-12

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

0.00

M 11-07-12 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

130



Brake NC

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

NC BRAKE

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Brake NC

Memo

0.00

Deburr if necessary  Form as per dwg D3512 using DT8179

Sb 11/07/25

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150



Large Fab

Large Fab

0.00

Memo

0.00

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004  Qty  
Description Batch  A/R 2059b Hardcoat Rod M18176

W/O:		WORK ORDER CHANGES					
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Revision ID:

Item Name: Wearplate

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Start Date: 7/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/18/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

170



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

180



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M117338  
Memo

START TIME:

1:15

OVEN TEMPERATURE:

FINISH TIME:

1:45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**Work Order ID 71795**

Tuesday, July 12, 2011 9:51:51 AM



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Item ID: D3512-1

Accept



Setup

Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 7/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/18/2011 Req'd Qty: 12.00



Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description**Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



QC3- Inspect Part Finish

0.00

12 4 11 1107124

QC

Quality Control

200

Identify as per dwg & Stock Location 500

0.00

117126 ② 8

Packaging

Packaging

Memo

0.00

210



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

117127 ② 8

11.01.24  
②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

Tuesday, July 12, 2011 9:51:58 AM

Page 1

Work Order ID: 71795



Parent Item: D3512-1



Parent Item Name: Wearplate

Start Date: 7/12/2011

Required Date: 7/18/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 06-06-20 JLM  
IPP Rev:B Now SS as per Rev B 06-12-15 JLM  
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased		No		100	sf	22.7000	0.261	3.296842		 B11-7-12	

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	22.7	
117275	1.7	
117653	21	

(18217)

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	71795
Description: Wearplate	Part Number:	D3512-1
Inspection Dwg: D3512	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>B</u>	Audited by:	<u>M</u>	Prototype Approval:	N/A
Date:	11-7-12	Date:	11-07-12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	08.01.16	Dimensions updated per Dwg Rev C	KJ/EC/DD	

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

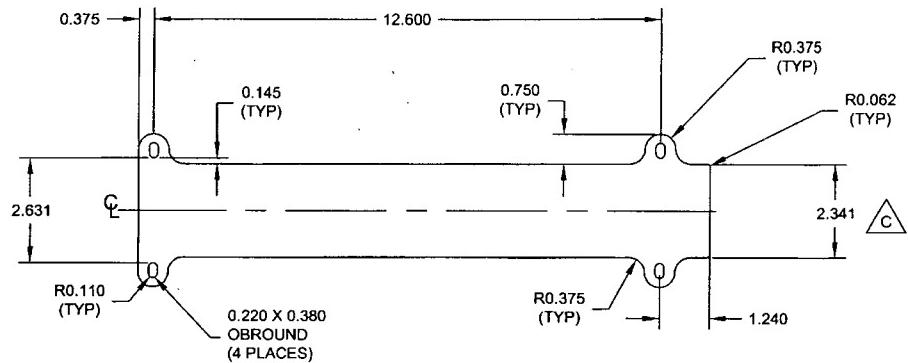
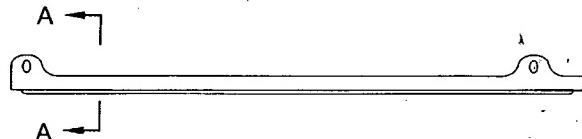
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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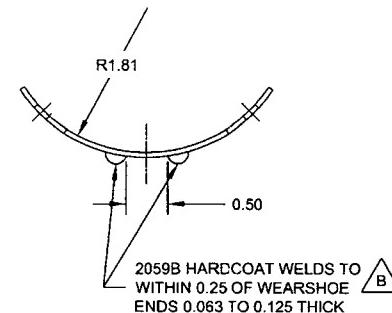
8 7 6 5 4 3 2 1

**D3512-1F FLAT PATTERN****D3512-1 BENDING DETAIL**

C

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

**SECTION A-A**  
SCALE 2:3

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 77795

*PL11-08-11*

**RELEASED**  
*07.11.08.11*

C	ENLARGE OBOUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA		
DESIGN	<i>PL</i>		
DRAWN	<i>PL</i>		
CHECKED	<i>PL</i>		
MFG. APPR.	<i>PL</i>		
APPROVED	<i>PL</i>		
DE APPR.	<i>PL</i>		
DATE	07.10.05		
DRAWING NO.	D3512	REV. C	SHEET 1 OF 1
TITLE	WEARPLATE	SCALE	1:3
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8 7 6 5 4 3 2 1

D

C

B

A

1

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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